

2

Work Order ID 76495

76495

Page 1

Tuesday, November 15, 2011 3:59:34 PM

Item ID: D3324-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Base Assembly

Start Date: 11/15/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	119441
4	D3324-3	Full Length Tube	119441
2	D3324-5	Top End Tube	119441
2	D3324-7	Bottom End Tube	119441
10	D3324-9	Vertical Tube	119441

2- Weld as per dwg

A/R 4130 rod batch: 118875

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

PC 11.11.23

11.11.23

IX

1 0 11.11.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

76495

Tuesday, November 15, 2011 3:59:34 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 11/15/2011 **Start Qty:** 1.00

*** 1 ***

Customer:

Required Date: 11/25/2011 Req'd Qty: 1.00

*** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

0.00
0.00

0.00

QC

Memo

Quality Control

121

Pressure Wash per QSI005 4.3

0.00

121

0.00

HandFinish

Memo

Hand Finishing

~~174 m-1 11/11/24~~

W/O:		WORK ORDER CHANGES					
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Work Order ID 76495

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Page 3

Tuesday, November 15, 2011 3:59:35 PM

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly
Start Date: 11/15/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/25/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference: Run Start ***NR1***
Stop ***NR2***
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							

130

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME: 8:50

OVEN TEMPERATURE: 400

FINISH TIME: 9:20

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 10:00

OVEN TEMPERATURE: 400

10:30

0.00

0.00

0.00

140

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

IXD M 11/11/24

EB 11/11/24

M 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76495***76495***

Page 4

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Item ID: D3324-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 11/15/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *6-A*

0.00

150

Packaging

Memo

*w/o
76488*

0.00

Packaging

CS 11/11/24 @

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*u/u/28**P11-25
①*

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Tuesday, November 15, 2011 3:59:40 PM

Page 1

Work Order ID: 76495

76495

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 *D3328-3* Basket Hinge		Manufactured	No			100	Each	18.0000	2	2			
									**			11/11/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				18					
				33872				18					
D3348-1 *D3348-1* Clevis		Manufactured	No			100	Each	15.0000	4	4			
									**			11/11/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
				75575				14					
				WA005				1					
				44246				1					
D3349-3 *D3349-3* Spacer Bushing		Manufactured	No			100	Each	4.0000	2	2			
									**			11/11/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
				72930				4					
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	8.0000	2	2			
									**			11/11/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				8					
				43228				8					

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

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76495

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

307.3682

46.6

49.05263

**

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

Location

Loc Qty

Loc Code

MAT034

307.3682

109127

158.152

109385

15.75

112786

39.2488

119441

57.8774

119506

36.34

49.05263

M569EX0.50-18F

Purchased

No

100

sf

146.0000

28

28

**

M569EX0 50-18F

569 Expanded Metal

Location

Loc Qty

Loc Code

MAT018

146

112776

10

117806

4

119226

4

119404

128

32

Tuesday, November 15, 2011 3:59:40 PM

Shop Packet Print

Page 2

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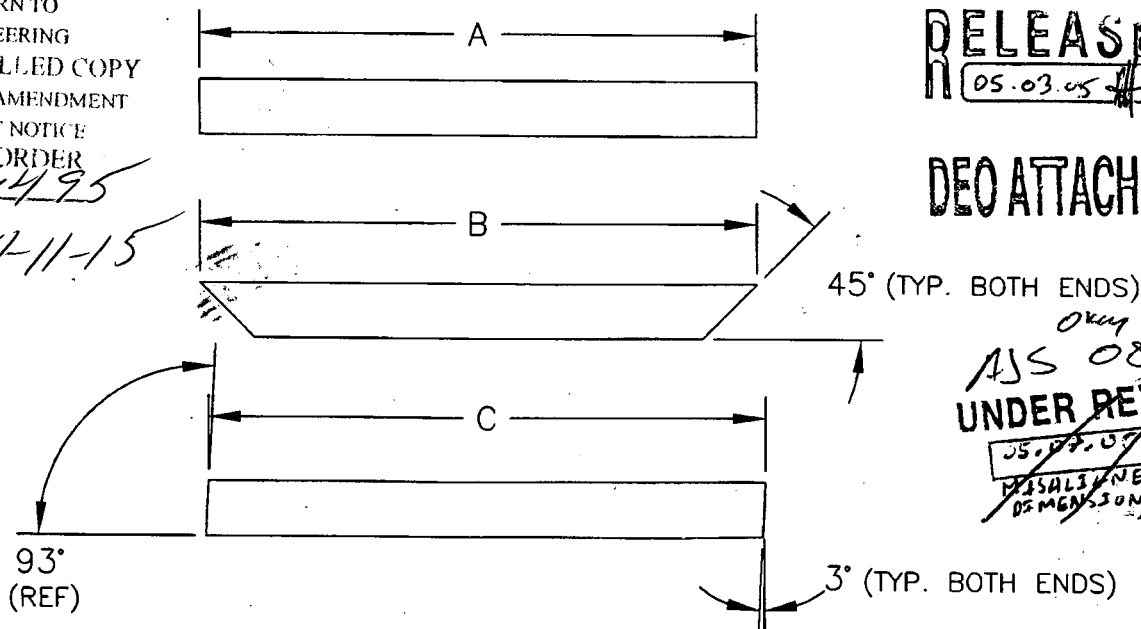
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **76495**

**RELEASED**
05.03.05**DEO ATTACHED**

08.12.15
UNDER REVIEW
05.07.07 PH
DISALIGNED
DIMENSION 162

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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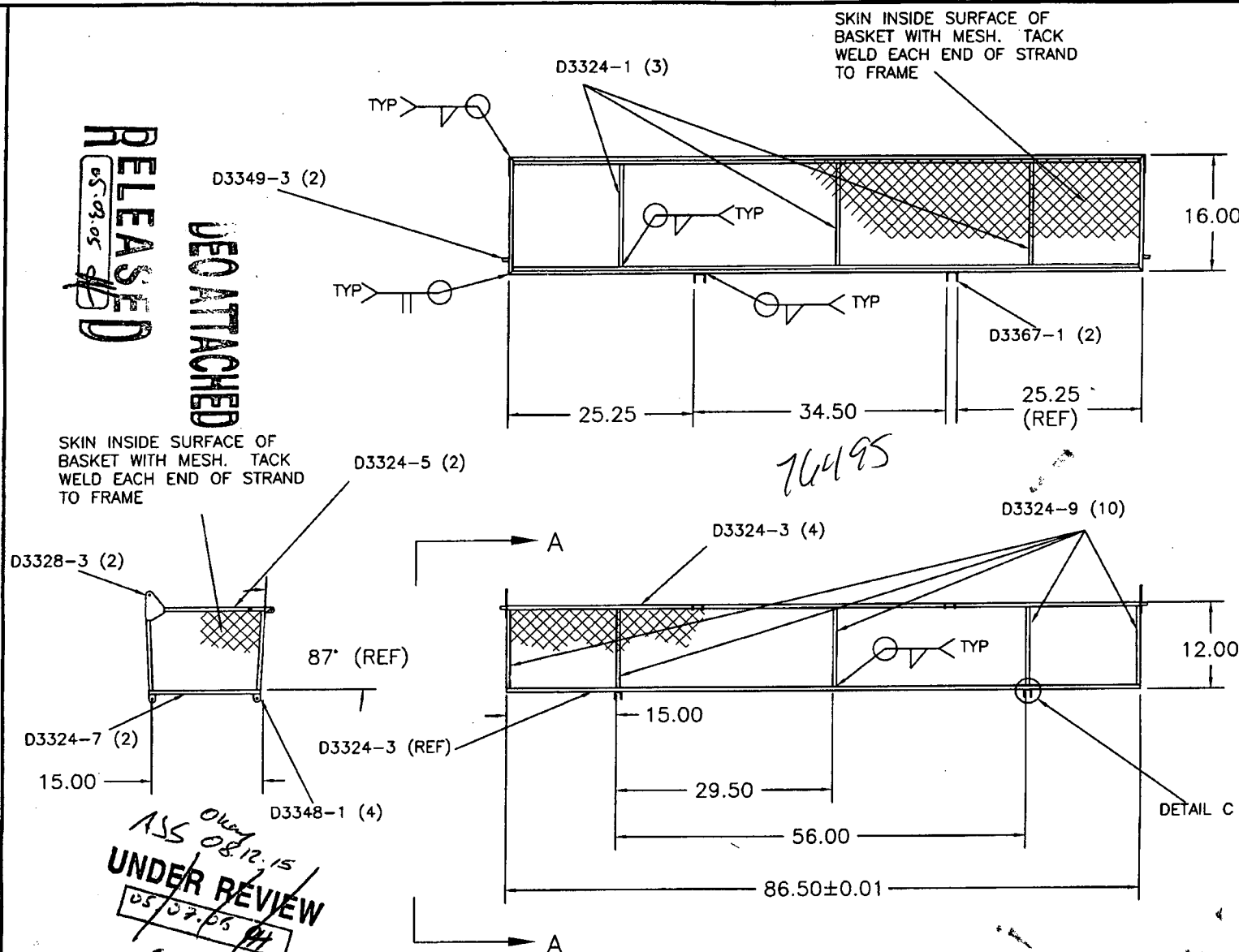
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3324
DATE	TITLE	REV. B
05.03.04	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE
		1:20



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DETACHED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

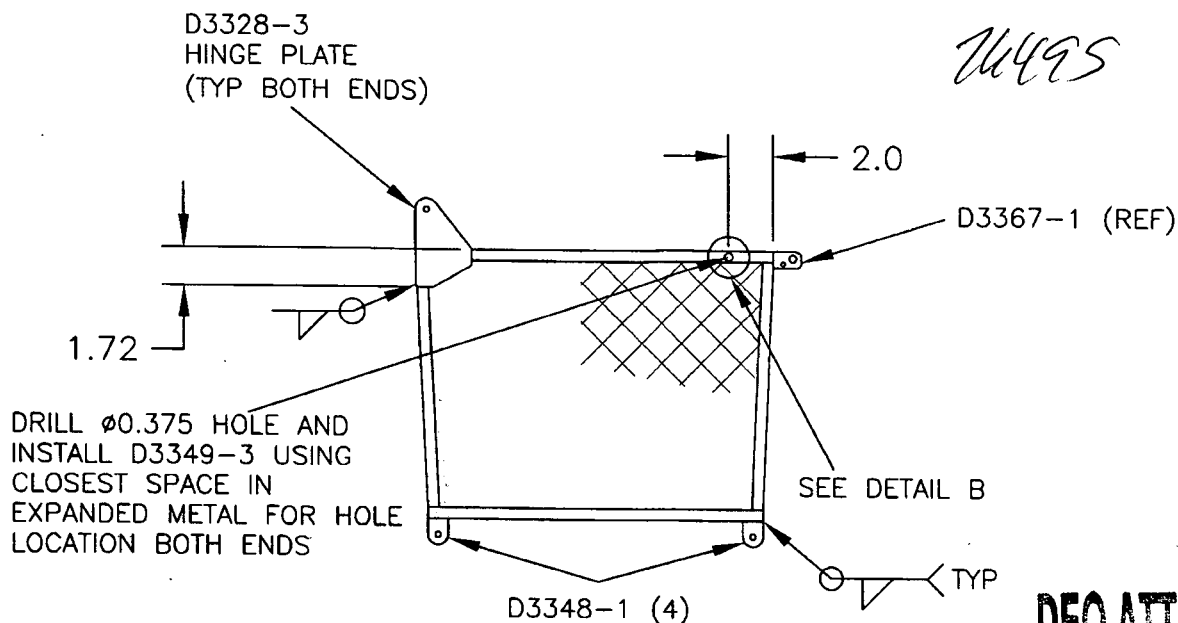
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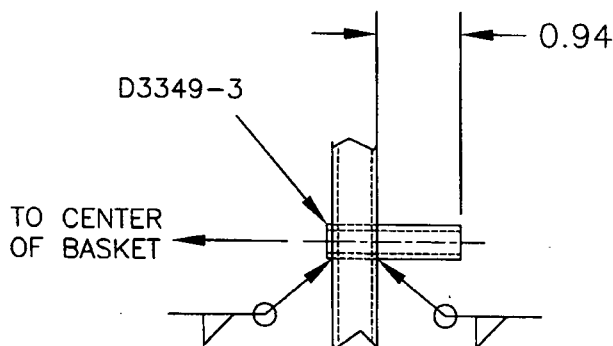
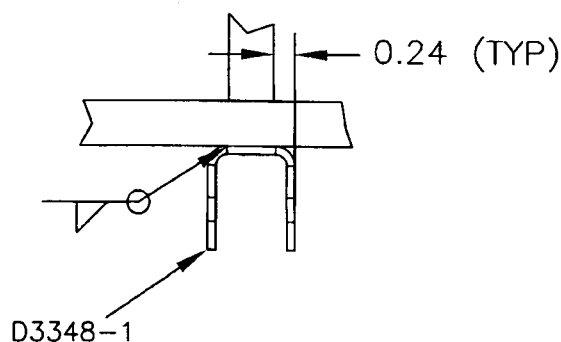
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



VIEW A-A

DEO ATTACHED

RELEASED
05.03.05DETAIL B
(SCALE 1:2)DETAIL C
(SCALE 1:2)

Okay
ASS 08.12.15
UNDER REVIEW
05.07.05

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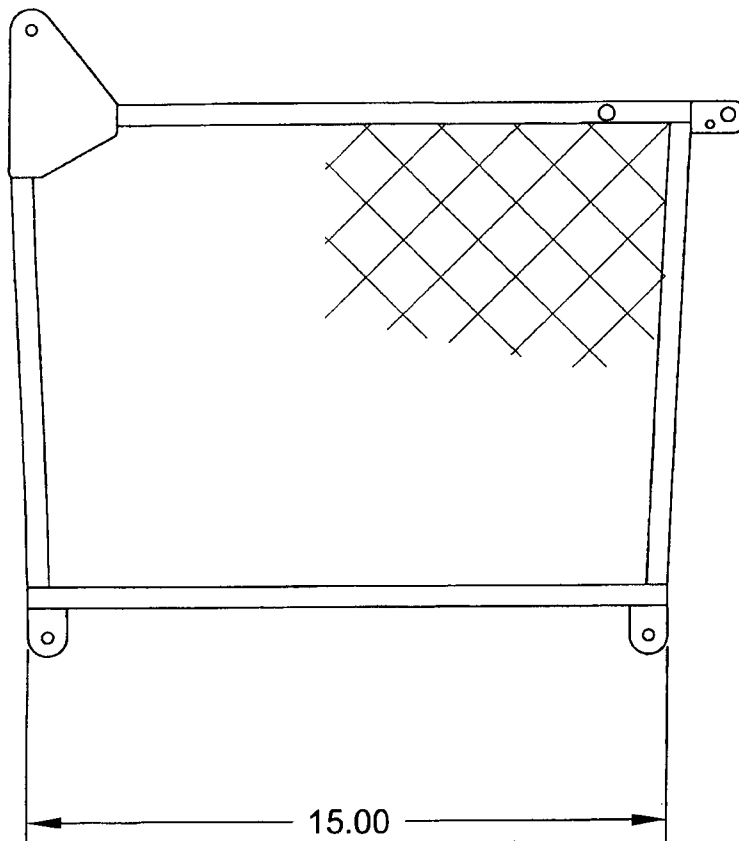
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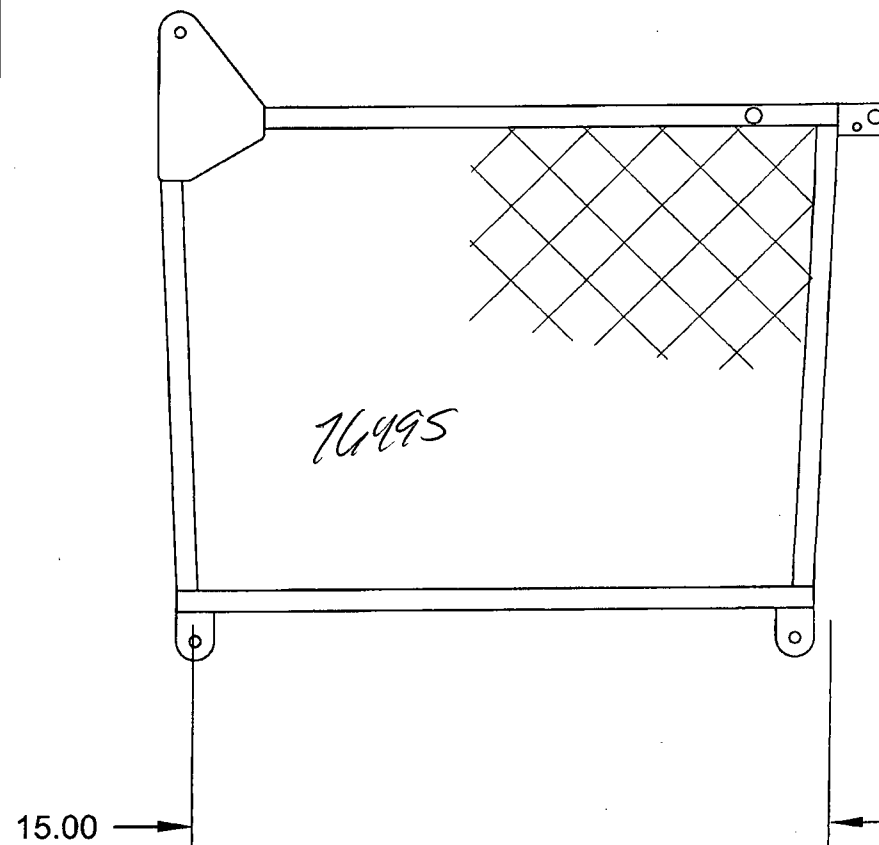
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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